

Date: Thursday, 20/11/2008 3:35:35 PM
 User: Julie Dawson

Process Sheet

Customer : CU-DAR001 Dart Helicopters Services	Drawing Name : DOUBLER
Job Number : 43630	
Estimate Number : 13550	
P.O. Number :	Part Number : D32343
This Issue : 20/11/2008 S.O. No. :	Drawing Number : D3234 REV A
Prsht Rev. : NC	Project Number : N/A
First Issue : / / Type : SMALL /MED FAB	Drawing Revision : A
Previous Run : 41252	Material :
Written By :	Due Date : 28/11/2008 Qty: 4 Um: Each
Checked & Approved By : <u>JUD 08.11.21</u>	
Comment : Est Rev:A New Issue 08-08-14 JLM Verified By:EC	

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
----------------	------------------------------	----------------------

1.0	M2024T3S050	2024-T3 .050 sheet
-----	-------------	--------------------



Comment: Qty.: 0.2273 sf(s)/Unit Total : 0.9093 sf(s)

2024-T3 .050 sheet

BATCH: 107711 B8-11-24

2.0	WATER JET	FLOW WATER JET
-----	-----------	----------------

**Comment:** FLOW WATER JET

1-Cut as per Dwg D3234

Dwg Rev: A B8-11-24Prog Rev: A

(S)

2-Deburr if necessary B8-11-24

3.0	QC2	INSPECT PARTS AS THEY COME OFF MACHINE
-----	-----	--

B8-11-24**Comment:** INSPECT PARTS AS THEY COME OFF MACHINE

4.0	QC8	SECOND CHECK
-----	-----	--------------

**Comment:** SECOND CHECKSosul25 +8

5.0	HAND FINISHING1	HAND FINISHING RESOURCE #1
-----	-----------------	----------------------------

**Comment:** HAND FINISHING RESOURCE #1

Chemical Conversion Coat as per QSI 005 4.1

m-h 08/11/25 (SX)

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Thursday, 20/11/2008 3:35:35 PM
User: Julie Dawson

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: DOUBLER

Job Number: 43630

Part Number: D32343

Job Number:



Seq. #:

Machine Or Operation:

Description :

6.0

QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



(5x)

Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION

8/4/25

90

7.0

PACKAGING 1

PACKAGING RESOURCE #1



5X

Comment: PACKAGING RESOURCE #1

Identify and Stock
Location: 237

8/11/25

500

8.0

QC21

FINAL INSPECTION/W/O RELEASE



08/11/26

JD

Comment: FINAL INSPECTION/W/O RELEASE

Job Completion



mk 08-11-25

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

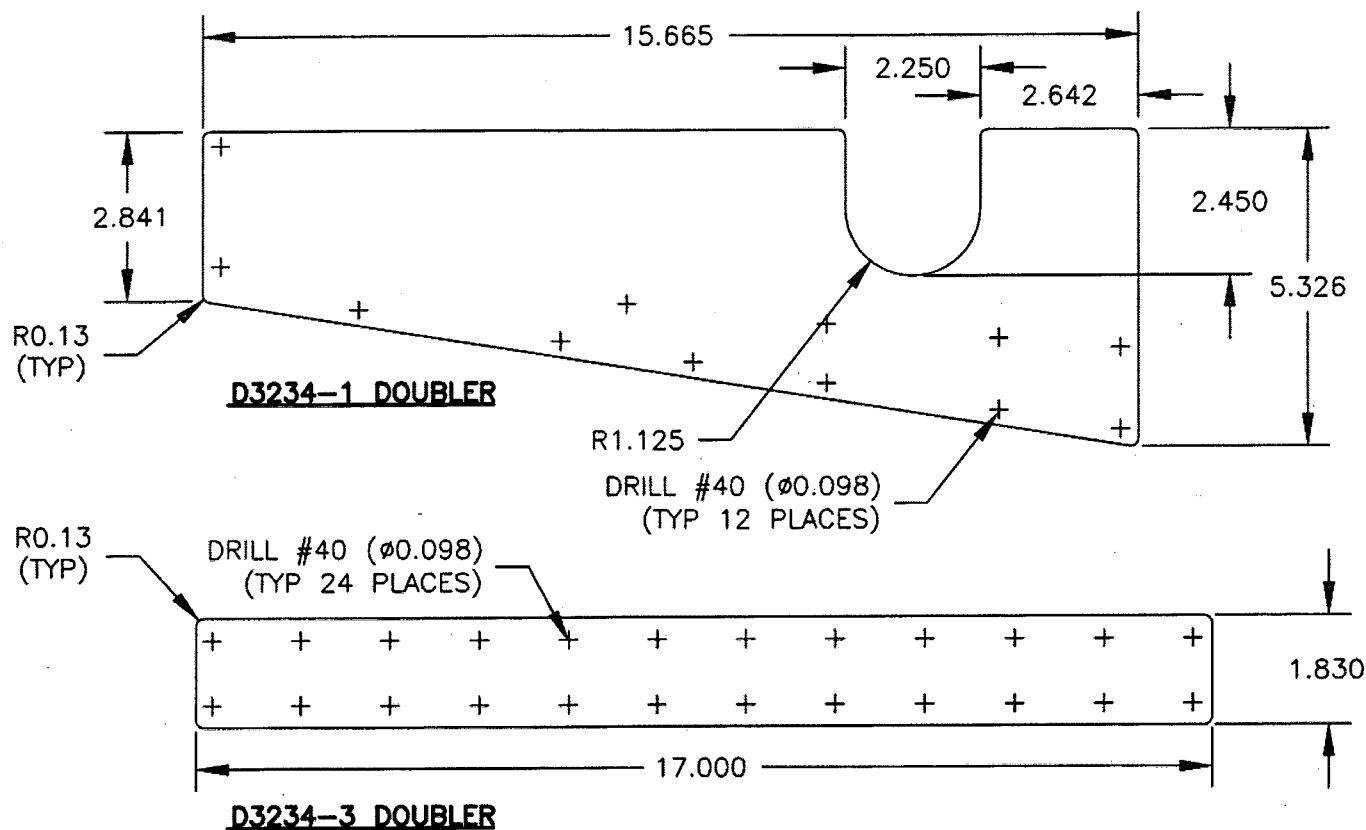
Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

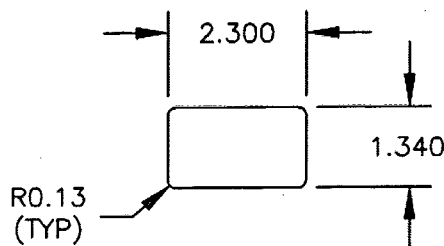


DESIGN LP	DRAWN BY LP	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED [Signature]	APPROVED [Signature]	DRAWING NO. D3234	REV. A SHEET 1 OF 1
DATE 03.11.19		TITLE DOUBLER	SCALE 1:3
A	03.11.19	NEW ISSUE	



RELEASED

03.11.24



D3234-5 SPACER

SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER

D3234-1/-3 DOUBLER. D3234-5 SPACER

- 1) MACHINE PARTS PER DWG FILE "D3234-A.DWG"
- 2) MATERIAL: -1/-3: 2024-T3 (QQ-A-250/4), 0.050 THICK (REF DART SPEC. M2024T3S.050)
-5: 5052-H32 (QQ-A-250/8), 0.050 THICK (REF DART SPEC. M5052H32S.050)
- 3) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
- 4) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED.
- 5) ALL DIMENSIONS ARE IN INCHES

Copyright © 2003 by DART AEROSPACE LTD

THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.